



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

C10-27

Job Sheet 192178



Part No: C10-27

Job Qty: 1 pcs

Part Name: Cage Weldment



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/18/19

Job Tracking No:

Due Date: 4/19/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG C10-27 Rev 9 IPP REV A RQ 17.09.05 VERIFIED BY DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Large Fab - Welded Assy-1	1 pcs	4/19/19	4/19/19	0.00	0.00	Large Fab - 1	<i>A</i>
							Large Fab - 10	
							Large Fab - 2	
							Large Fab - 3	
							Large Fab - 4	
							Large Fab - 5	
							Large Fab - 6	
							Large Fab - 7	
							Large Fab - 8	
							Large Fab - 9	
120	QC 9	1 pcs	4/19/19	4/19/19	0.00	0.00	QC 9 - 10	APR 17 2019
							QC 9 - 18	
							QC 9 - 24	
							QC 9 - 43	
							QC 9 - 50	
							QC 9 - 9	
140	Powdercoat - 6 Fire Red - B4B	1 pcs	4/19/19	4/19/19	0.00	0.00	Powdercoat - 1 - B4B	
							Powdercoat - 2 - B4B	
							Powdercoat - 3 - B4B	
							Powdercoat - 4 - B4B	
160	QC 3	1 pcs	4/19/19	4/19/19	0.00	0.00	QC 3 - 10	DAS 28 9-89
							QC 3 - 13	
							QC 3 - 15	
							QC 3 - 17	
							QC 3 - 18	
							QC 3 - 2	
							QC 3 - 28	
							QC 3 - 3	
							QC 3 - 30	
							QC 3 - 34	
							QC 3 - 36	



Container No: S172915



Part: C10-27

Job No: 192178

Serial No/Batch: S172915

Revision: 9

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 04/16/19

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					

				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
180	Packaging 3-1 - Stock - B4B	1 pcs	4/19/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
200	QC 21 - SA	1 pcs	4/19/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

Part Op **100** - (Weld per dwg A/R Steel rod Batch: _____) US WELD FIXTURE C-10
 Descriptions: **120** - (QC9- Inspect visual per QSI004- Fusion Welds)
140 - (Fire Red(Ref:4.3.5.10) per QSI005 4.3) START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____
160 - (QC3- Inspect Part Finish)
180 - (Identify as per dwg & Stock Location: _____)
200 - (QC21- Final Inspection - Work Order Release)

DAS
28
9-89

DAS
APR 18 2019
70
9-89

Location
CORNER
GA
AGAIN

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

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Other/Details:					

Job BOM					00927
Part / Item	Component Name	Quantity	Operation	Container	
C10-27-1	Lifting Plate	2 pcs (2 ea)	100-Large Fab - Welded Assy-1	5083861	
C10-27-10	Side Loop Wrap Around	2 pcs (2 ea)	100-Large Fab - Welded Assy-1	5102110	
C10-27-2	Cage Reinforcement	2 pcs (2 ea)	100-Large Fab - Welded Assy-1	5159590	
C10-27-3	Front Guard Plate	1 pcs (1 ea)	100-Large Fab - Welded Assy-1	5084783	
C10-27-4-1	Top Ring	2 pcs (2 ea)	100-Large Fab - Welded Assy-1	5172892	
C10-27-8	Bumper Plate	1 pcs (1 ea)	100-Large Fab - Welded Assy-1	5084735	
C10-27-9	Space Bar Wrap Around	2 pcs (2 ea)	100-Large Fab - Welded Assy-1	5103186	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Large Fab - Welded Assy-1	C10-27-1	2	2	0	
	C10-27-10	2	2	0	
	C10-27-2	2	0	0	
	C10-27-3	1	8	0	
	C10-27-4-1	2	0	0	
	C10-27-8	1	8	0	
	C10-27-9	2	2	0	
Part Specifications					
Specifications could not be found.					

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

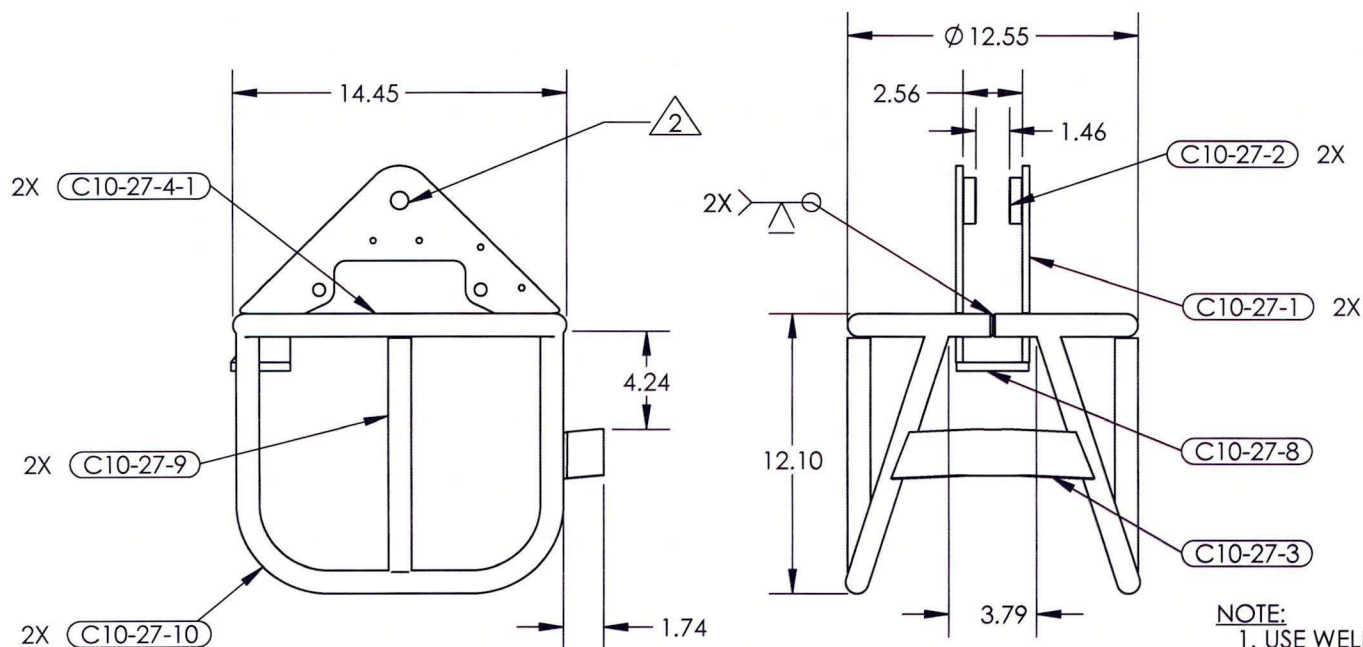
NCR No. _____

Route update only ☐

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Other/Details:					

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
6		AS DRAWN BY APICAL	1/9/2013	JAG	
7		CH'D 1.27 DIMENSION TO 1.75 TO MATCH PARTS	1/9/2013	JAG	
8		-9 CH'D LENGTH WAS 10 IS 10-1/8. -10 ADDED COPING 2X R .5 X .25 DEEP.	2/27/2013	BIM	JAG
9	16-0169	-9 DELETED FINISH SPEC WAS RAL 3000 IS NO SPEC, CH'D NOTE 1 ADDED C10, ADDED NOTE Δ CH'D DWG TO SHEET METAL TOLERANCE.	10/13/2016	RJC	JAG



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 192178 MWS
19-03-18

NOTE:
1. USE WELD FIXTURE C-10, WELD ALL CONNECTIONS 100%.

Δ HOLES MUST ALIGN.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description
			C10-27-1	2	LIFTING PLATE
			C10-27-2	2	CAGE REINFORCEMENT
			C10-27-3	1	FRONT GUARD PLATE
			C10-27-4-1	2	TOP RING
			C10-27-8	1	BUMPER PLATE
			C10-27-9	2	SPACE BAR WRAP AROUND
			C10-27-10	2	SIDE LOOP WRAP AROUND

DART AEROSPACE	
TITLE CAGE WELDMENT	
DWG NO. C10-27	REV 9
MAT'L HEAT TREAT FINISH POWDER COAT RED	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125/✓
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: APICAL	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: DUERFELDT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:8	DATE 9/26/2006 SHEET 1 OF 1